

[illegible]

Page 1

Accept

[illegible]

Setup Start

Stop

[REDACTED]

[REDACTED]

Cust Item ID:

Customer:

Reference:



Date: 10-2-14

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

[illegible]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60564

Wednesday, July 14, 2010 9:18:22 AM



Page 2

Item ID: D3278-1

Accept



Setup

Start



Revision ID:

Item Name: Support

Stop



Start Date: 7/14/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

MJ= 10/09/19

24

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

24 BL 10-7-21

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

24 BL 10-7-21

Powder Coating

START TIME:

3:25

OVEN TEMPERATURE:

320° FINISH TIME:

3:55

W/O:		WORK ORDER CHANGES						
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Work Order ID 60564

Wednesday, July 14, 2010 9:18:22 AM

Page 3

Item ID: D3278-1

Revision ID:

Item Name: Support

Start Date: 7/14/2010 Start Qty: 24.00

Required Date: 7/22/2010 Req'd Qty: 24.00

Reference:

Accept

Setup

Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

44 10/07/27

24 0

Quality Control

170

Identify as per dwg & Stock Location: 45

0.00

Packaging

Memo

0.00

Packaging

10-7-24 24 0

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/07/25 MF 10-7-22

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 14, 2010 9:18:27 AM

Page 1

Work Order ID: 60564

Parent Item: D3278-1

Parent Item Name: Support



Start Date: 7/14/2010

Start Qty: 24.00

Required Date: 7/22/2010

Required Qty: 24.00

Comments:

IPP: ☐A☐04.04.19☐New issue☐KJ/JLM☐

IPP B 07.09.06 rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	62.2300	0.2337	5.904			
6061-T6 Bar 1.00 x 2.00													

Location

Loc Qty

Loc Code

MAT

60

112567

0

→ 115045

60

MAT03

2.23

112567

2.23

5.404 ml 7/17/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	60564
Description: Support		Part Number:	D3278-1
Inspection Dwg: D3278	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.100	/			
0.359	+/-0.005	.358	/			
0.609	+/-0.010	.613	/			
0.250	+/-0.010	.252	/			
1.480	+/-0.005	1.480	/			
R0.125	+/-0.010	R.125	/			
0.119	+0.005/-0.004	.123	/			
2.439	+/-0.010	2.441	/			
1.980	+/-0.010	1.982	/			
R0.13	+/-0.030	R.130	/			
Ø0.257	+0.005/-0.000	Ø.260	/			
R0.375	+/-0.010	R.377	/			
0.875	+/-0.010	.875	/			
0.500	+/-0.010	.502	/			
R0.400	+/-0.010	R.400	/			
R1.00	+/-0.030	R1.00	/			
1.720	+/-0.010	1.723	/			
R0.125	+/-0.010	R.125	/			
0.125	+/-0.010	.128	/			

Measured by:	SWL	Audited by:	MW	Prototype Approval:	N/A
Date:	10/07/19	Date:	10/07/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	

W/O:			WORK ORDER CHANGES					
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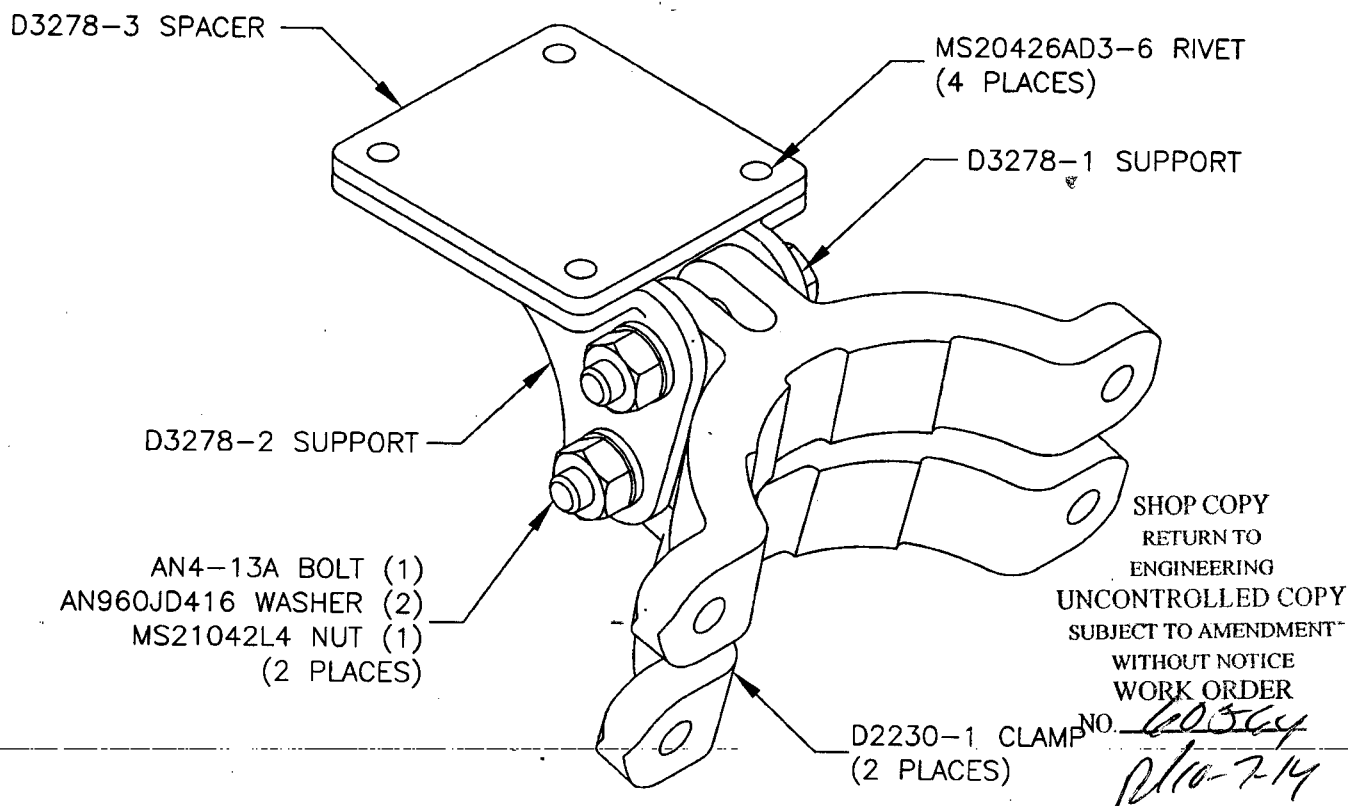
NOTE: Date & initial all entries



DESIGN <i>97</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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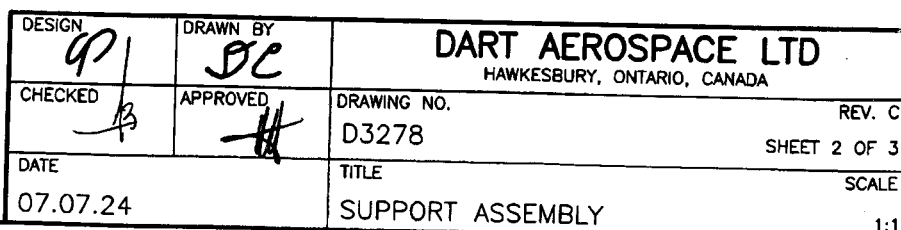
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

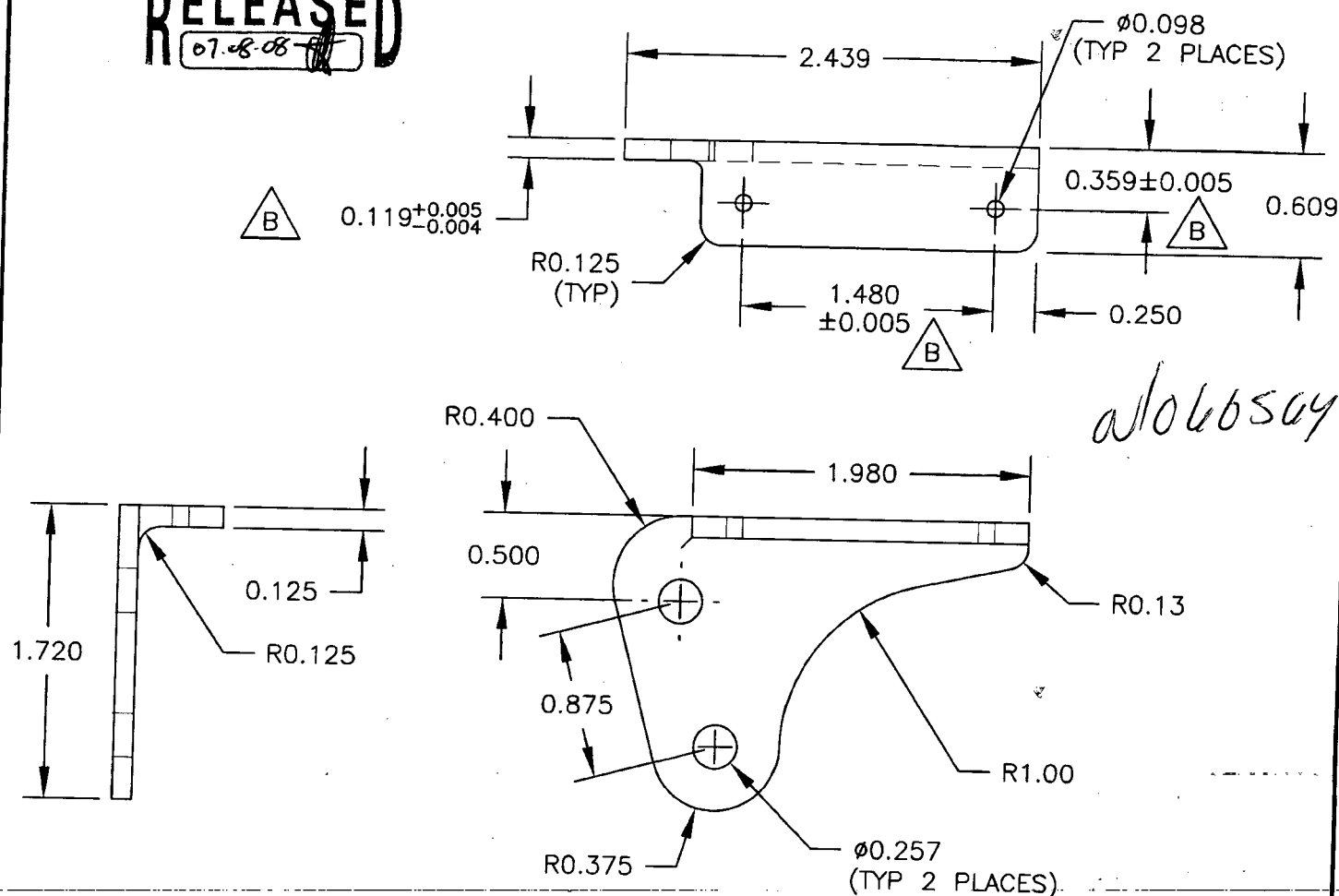
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07-08-08



D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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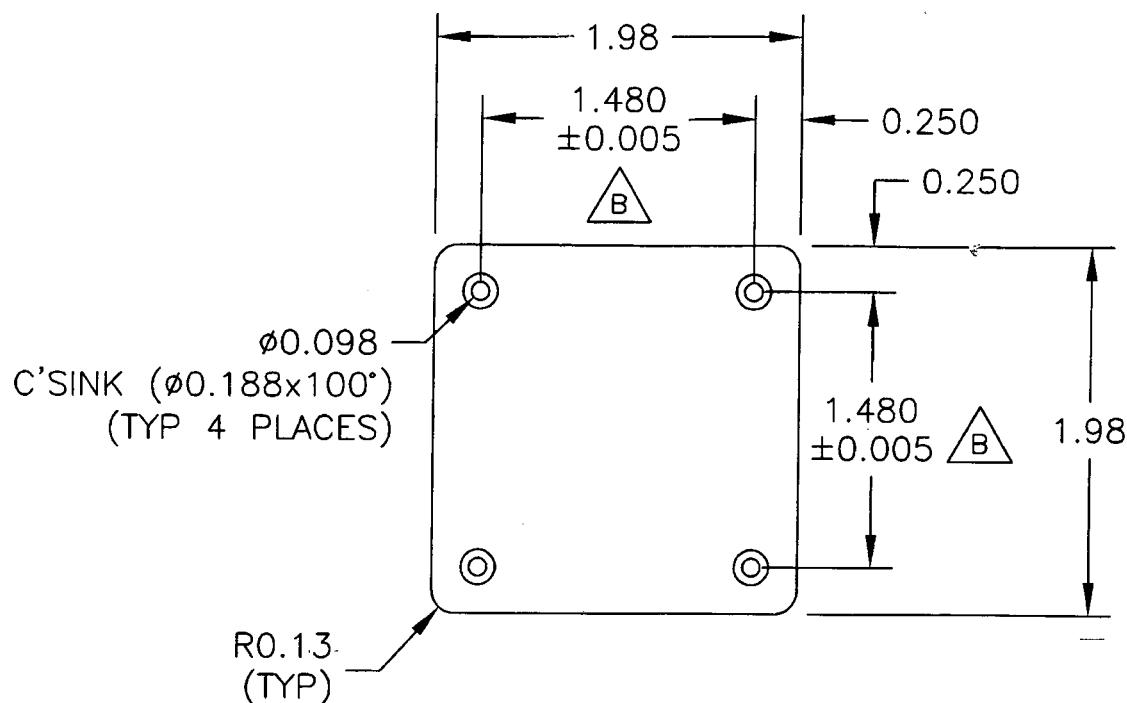
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>sc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08*W1060564***D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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